

Date: Monday, 3/26/2007 2:58:38 PM  
 User: Jean-Luc Menard

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : DOOR DOUBLER
Job Number : 31509	
Estimate Number : 12681	
P.O. Number : <i>N/A</i>	Part Number : D35943
This Issue : 3/26/2007 S.O. No. : <i>N/A</i>	Drawing Number : D3594 UNDER REVIEW
Prsht Rev. : NC	Project Number : AC0001
First Issue : <i>N/A</i> Type : SMALL / MED FAB	Drawing Revision : U/R
Previous Run : 30973	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 4/2/2007 Qty: 2 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est Rev : A New Issue 07-01-22 EC	

Additional Product

FOR ENGINEERING USE ONLY

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6S080 6061-T6 .080 Sheet


 CERTIFICATE OF CONFORMITY  
 REQUIRED

 Comment: Qty.: 0.5355 sf(s)/Unit Total : 1.0710 sf(s)  
 6061-T6 .080 Sheet  
 Batch: *M101178*
*M 07 03 27 (2)*

2.0 WATER JET FLOW WATER JET


 Comment: FLOW WATER JET  
 1-Cut as per Dwg D3594  
 Dwg Rev: *U/R*  
 Prog Rev: *U/R*
*M 07 03 27*
*(2)*

2-Deburr if necessary

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE


*(2)*

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



ENGINEERING APPROVAL

Comment: SECOND CHECK

 ENGINEERING  
 APPROVAL

*307.03.27*  
*07.03.28*

5.0 SMALL FAB 1 SMALL &amp; MEDIUM FAB RESOURCE 1



Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

Deburr if necessary.

*[Signature]*

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR DOUBLER

Job Number: 31509

Part Number: D35943

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

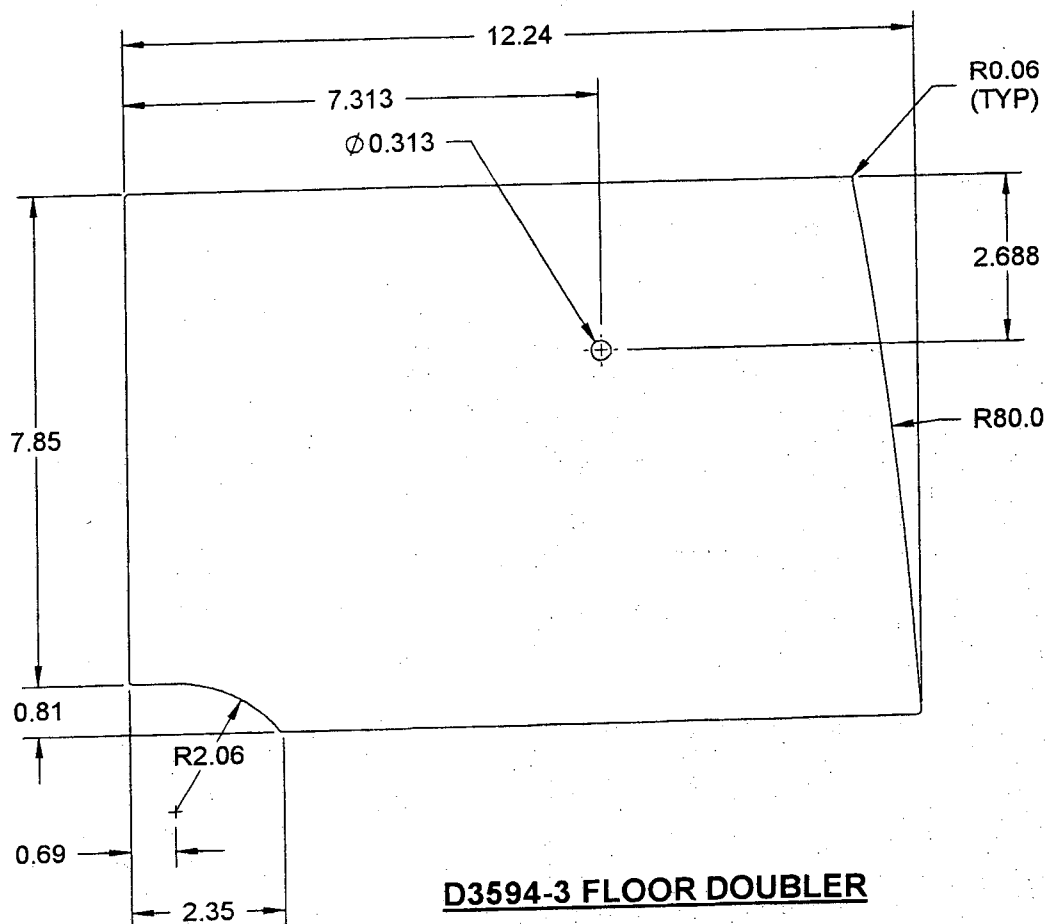
Job Completion



U 07.16.22

PRELIMINARY ISSUE

DESIGN <i>B</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED	DRAWING NO. D3594	REV. A SHEET 2 OF 2
DATE 07.01.29		TITLE FLOOR DOUBLER	SCALE 1:3



NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK, PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF. DART SPEC. M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3594-3" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 31509
<b>Description:</b> Door Doubler		<b>Part Number:</b> D3594-3
<b>Inspection Dwg:</b> D3594	<b>Rev:</b> U/R	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☐ First Article
 ☒ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	Ø 0.313	+0.006-0.001	0.314	✓		VERN	
B	7.85	+1-0.030	7.848	✓		VERN	
C	12.24	+1-0.030	12.240	✓		Height Gauge	
D	7.313	+1-0.010	7.313	✓		VERN	
E	2.688	+1-0.10	2.687	✓		VERN	
F	2.35	+1-0.030	2.347	✓		Height Gauge	
G	0.81	+1-0.030	0.812	✓		Height Gauge	
H	0.080	+1-0.010	0.078	✓		VERN	
I							
J							
K							
L							
M							
N							
O							
P							
Q							
R							
S							
T							
U							
V							
W							
X							
Y							

<b>Measured by:</b> MM. M	<b>Audited by:</b> E	<b>Prototype Approval:</b> N/A
<b>Date:</b> 07.03.28	<b>Date:</b> 07.03.28	<b>Date:</b> N/A

Rev	Date	Change	Revised by	Approved
		New Issue	KJ/RF	